Qty:

Date: User

Tuesday, 11/27/2007 7:49:09 AM

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 35996

Estimate Number

P.O. Number This Issue

: 10346 : NIA : 11/27/2007

: 35995

: LANDING GEAR Type

Part Number

Drawing Number

Drawing Name

Project Number **Drawing Revision**

Material Due Date : D2596

D2596 REV D

: 205 SKIDTUBE "I" BEAM

: N/A

: 12/6/2007

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est: D 99.02.02

Changed QA to QC, Added Step 6 and Cost D

Est Rev:E 07-07-09 Incorperated DEO 9183 JLM

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

D25003100

1.0000 Each(s)

Ext'n -`I' Beam Web 4"

Comment: Qty.: 1.0000 Each(s)/Unit Extrusion "I" Beam Web 4"

Pick;

Qty

Part Number D2500-3-100

Description

Total:

Extrusion

7-11-27

2.0

LANDING GEAR 1







1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30

- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

3.0 HAND FINISHING HAND FINISHING RESOURCE #1





Comment: HAND FINISHING RESOURCE #1

4.0

Acid Etch and Alodine per QSI 005 4.1 QC5





Comment: INSPECT WORK TO CURRENT STEP

Page 1

	Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		(Z)			1						
Part No	:	P/	AR #: Fault Category:	NCF	R: Yeş	No) DQ	A : <u>\(\(\)</u>	Date: <u>C</u>	7/11/27		
	· v				,	N/C Close					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	·	\\:6:4:				
DATE	STEP	Section A	Initial Chief Eng	Action Description Sign & Date		Verification Section C	Approval Chief Eng	Approval QC Inspecto		
4				4.						
£7										
				9						

NOTE: Date & initial all entries

Date: User:

Tuesday, 11/27/2007 7:49:09 AM Kim Johnston

Customer: CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 35996

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

6.0

QC21

C. Tara



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u D.11.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								· ·	
DATE	STEP	STEP		PROC	EDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA: Date:	
			QA: N/C Closed: Date:	

NCR:		` W	ORK OR	DER NON-CONFORMANCE		و من		
		Description of NC	Corrective Action Section B			Verification	A	Ammassal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval > Chief Eng	Approval
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NOTE: Date & initial all entries



DATE 07.04.17 CHECKED O 0 Φ \triangleright P 98.09.14 96.09.16 97.07.23 07.04.17 D2596 205 DRAWING NO INCORPORATED DEO 9183 INCORPORATED DEO 9097 Ø0.63 HOLE NEW ISSUE WEB DART RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA WAS ø0.56 SHEET

1 OF 1 REV.

SCALE

1:20

	1.750 - 3.500 - 1	.750
REFER TO DETAIL A	1.750	Ø0.63 2 PLACES) — 0.50 (REF)
-	8.75 - 17.38 -	REFER TO DETAIL A
\wedge	26.00 — 32.75 (RE 4 EQUAL SP 8.19 PITC	ACES 🗝 📗 📗
SUBJECTION WORLD	50.56 — 85.59	
TO A S E	91.30	
DOEGO WED		

D2596 WEB

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ANY PURPOSE

OR COPIED

- MATERIAL: 1) MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES

DETAIL ASCALE 1:4

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) 5) DEBURR SHARP EDGES 0.010 JO 0.020



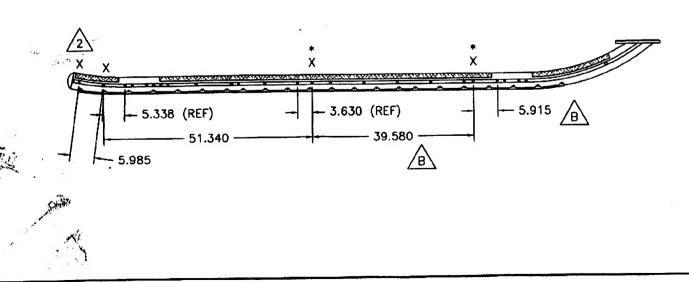
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	CHECK	ŒĐ	APPROVED	DRAWING NO.	REV. B
ı	•	Ø-	#	DEO 9183 SHEET	1 OF 1
	DATE	<u> </u>	<u> </u>	TITLE	SCALE
	00.0	5.15		ADD SKIDTUBE P/N D2580-045	NTS
	Α		00.03.29	NEW ISSUE	
	В		00.05.15	39.580 WAS 39.620	

DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045-ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.
 - a) DRILL Ø0.508 HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES 0.030 x 45°. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO Ø0.63 AND TOUCH UP WITH ALODINE PER QSI 005 4 1
 - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
 - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
 - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION Ø0.380-Ø0.390.
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



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